

Thursday, 5/10/2007 2:25:36 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B HIGH GEAR WEB
Job Number : 32279	
Estimate Number : 10455	
P.O. Number : <i>N/A</i>	Part Number : D26543
This Issue : 5/10/2007	Drawing Number : D2654 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : E1
Previous Run : 30724	Material : <i>N/A</i>
Written By : <i>HA 07.05.10</i>	Due Date : 5/17/2007
Checked & Approved By : <i>HA 07.05.10</i>	Qty: 4 Um: Each
Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedure DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	<i>B 29985</i>

(B)

Job 7-5-14

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

Job 7-5-14

(PTO)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

(B)

7-5-23

(PTO)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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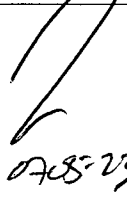


Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Job 7-5-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/05/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0705-23	2.0	1 web scrap. was cut + • 450" too short. Human error.	 Q51042	destroy web & replace. Ensure the length is to DWG before cutting. Measure twice, cut once.	JD 7-5-23	 0705-23	 Q51042	 0705-23

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:25:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 32279

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-5-23

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: LG

JID 7-5-23 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

15 07/05/24

Job Completion



u 07-05-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

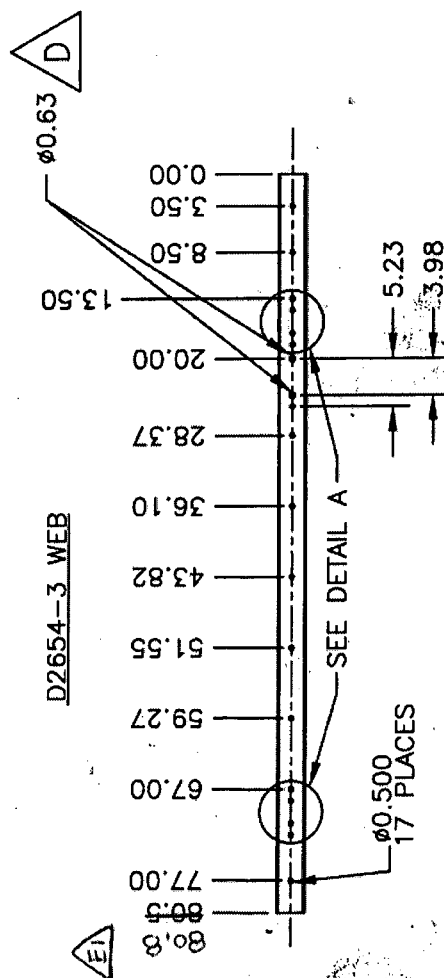
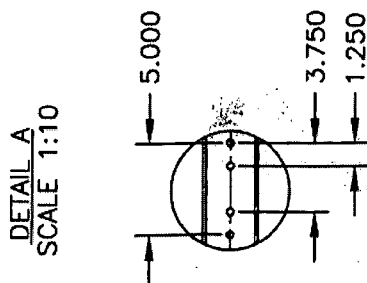
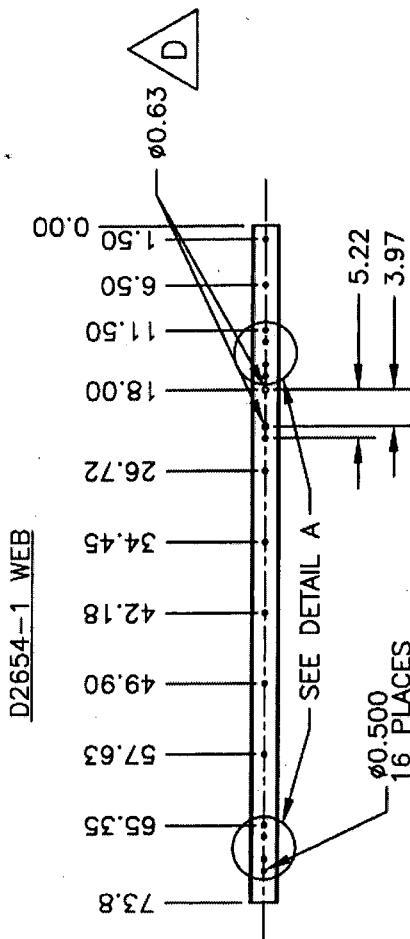
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO Ø0.63	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1	<i>CP</i> 04.08.24	PER TOOLING; Ø0.8 WAS Ø0.5	

RELEASED
04.06.22

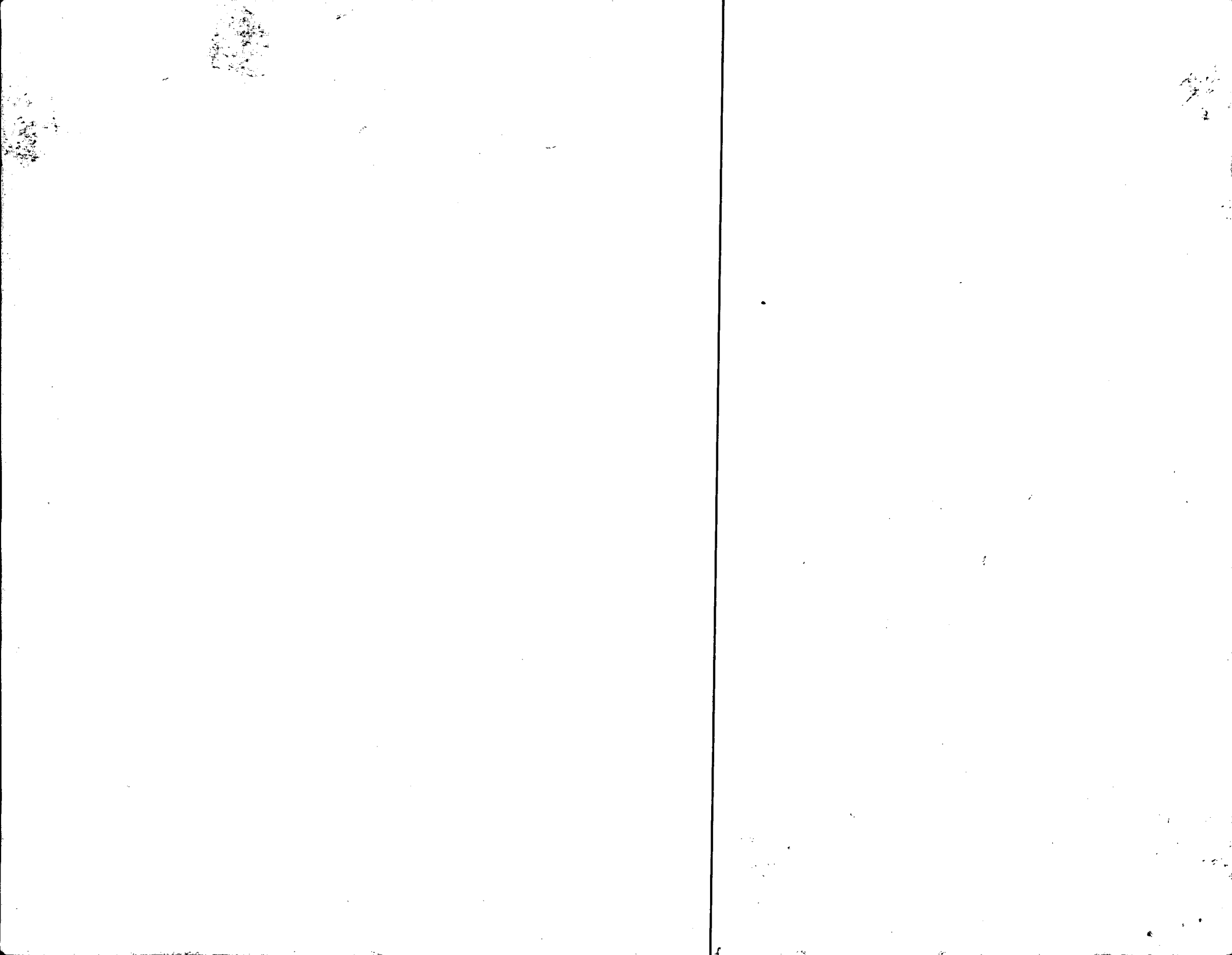


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WORK ORDER
NO. 32279

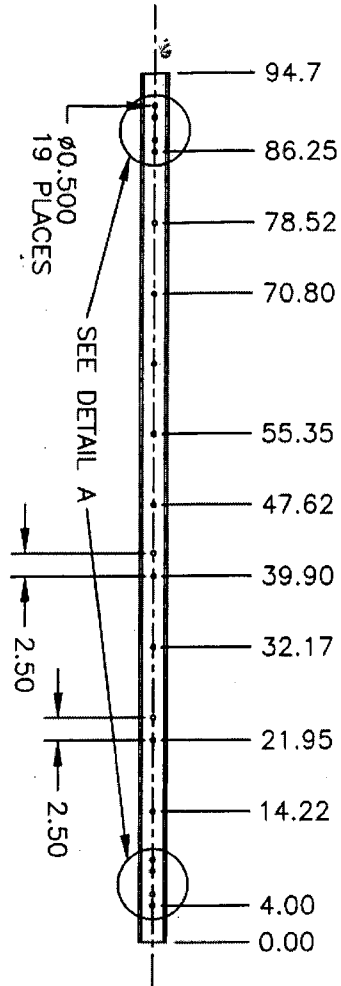
MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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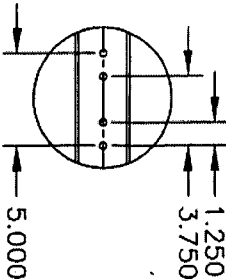
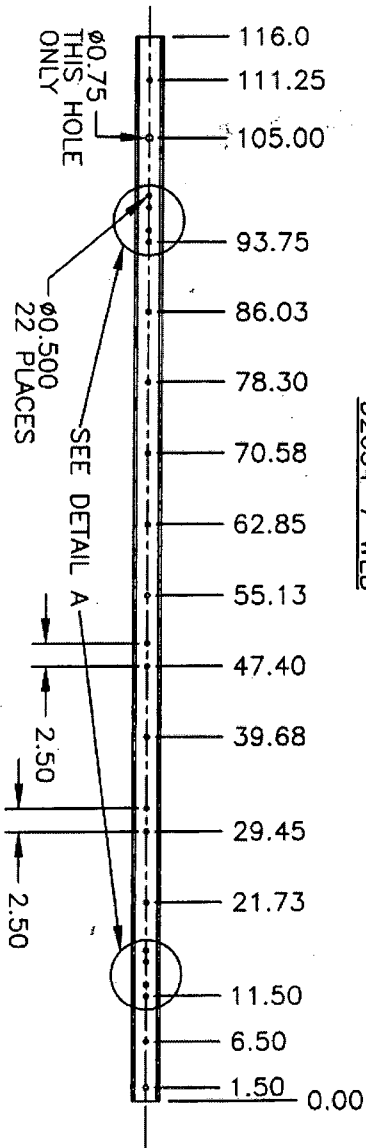


D2654-5 WEB



DETAIL A
SCALE 1:10

D2654-7 WEB



NO. 32279
WORK ORDER
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SHOP COPY

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.05.26

DATE	04.05.26	WEB	1:20
CHECKED	APPROVED	TITLE	SCALE
DESIGN	DRAWN BY	DRAWING NO.	REV. E
DART AEROSPACE USA, INC.	PORT HADLOCK, WA	D2654	SHEET 2 OF 2

